

## Quality Control

LB 9-7-23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50784

July 22, 2009 12:47:02 PM

Page 2

Item ID: D3891-042

Accept

Revision ID: A

Item Name: Panel, Fwd RH

Setup Start

Stop

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/24/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Deburr if necessary

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging



⇒ 802/07/23

(XV)

φ

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M-L 09/07/24

(4X)

W/O:		WORK ORDER CHANGES					
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July 22, 2009 12:47:02 PM



Page 3

Item ID: D3891-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Fwd RH

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00



Small Fab

Memo

0.00

1- Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: M111428

Small Fab

M-2 09/07/24 (4X)

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

2) Sced/bat

(4) 4

170

0.00



Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

0.00

Packaging

09/07/24 (4)

**Dart Aerospace Ltd**

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July 22, 2009 12:47:02 PM



Page 4

Item ID: D3891-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Panel, Fwd RH

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27 *[Signature]*

MF 09-07-24

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries



# Picklist Print

July 22, 2009 12:47:02 PM

Page 1

Work Order ID: 50784

Parent Item: D3891-042RevA

Parent Item Name: Panel, Fwd RH

Comments:

Start Date: 07/22/2009

Required Date: 07/24/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	709.8406	16.0408			
GE PLASTICS LEXAN SHEET												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	709.8406316	
103106	7.8	
105330	54	
109455	0.03	
111710	648.010632	

D3891-4RevA

Manufactured No

140 Each 0.0000 4.0000

Gasket

11710 1B 9-7-23

50794. MK

09-07-24

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

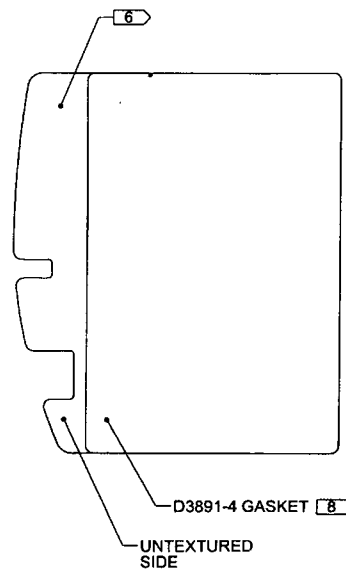
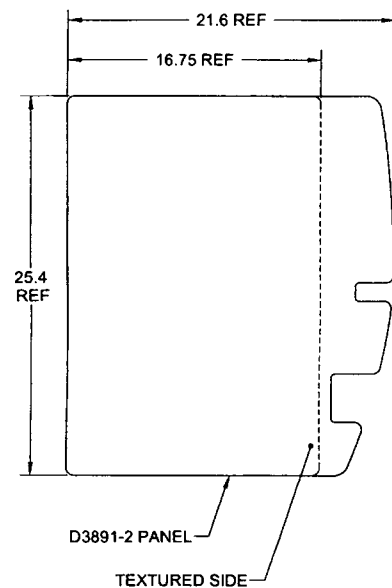
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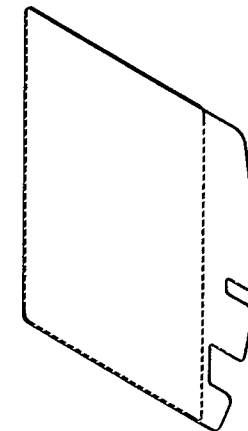
## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-042 PANEL, FWD RH**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

**RELEASED**  
09/05/01

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	<b>D3891</b>	SHEET 2 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	<b>PANEL, FWD</b>	NTS
DATE	09.05.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

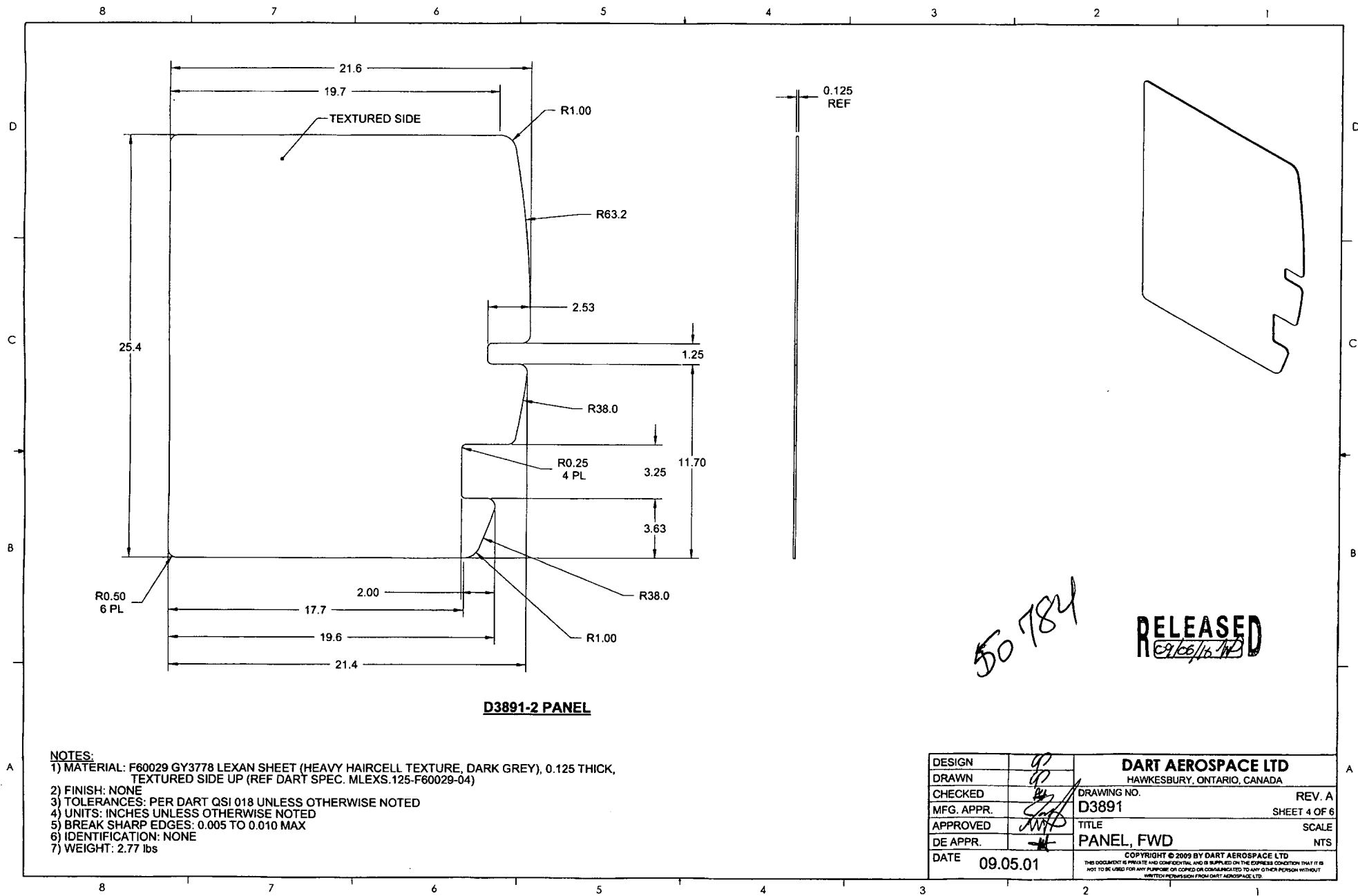
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50784

RELEASED  
09/06/16

**D3891-2 PANEL**

**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D3891	SHEET 4 OF 6
APPROVED	90	TITLE	SCALE
DE APPR.	90	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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